

Work Order ID 86822

86822

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July-06-12 3:00:00 PM

Item ID: D3245-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Access Panel Assembly
 Start Date: 7/06/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: 12-07-9 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3245	Rev B								
100	Pick Kit	0.00				4X			PS 12/07/12
100									
Packaging	Memo	0.00							
Packaging									
110	Small Fab	0.00				4X			PS 12/07/12
110									
Small Fab	Memo	0.00							
Small Fab	Install Nut Plates and D3245-5 angle as per Dwg D3245, follow instructions of note 8 on dwg when riveting angle, be careful when countersinking...mat'l very thin								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS 16 17/07/12

4X

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Quality Control

mf
12-07-23

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Picklist Print

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Work Order ID: 86822
Parent Item: D3245-041
Parent Item Name: Access Panel Assembly

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue 07-09-11 JLM Verified By:EC
IPP Rev:b ECN 1052 07-10-31 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2350-18-C3Y RIGID RECEPTACLE		Purchased	No			110	Each	57.0000	8	32		8/12/07/19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST399		35				32			
				121499		35							
				ST400		22							
				105729		2							
				19688		20							
D3245-1 Panel		Manufactured	No			110	Each	0.0000	1	4		8/12/07/19	
D3245-5 Door		Manufactured	No			110	Each	26.0000	1	4		8/12/07/19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		26				22			
				82305		2							
				83468		24							
MS20427M3-3 Rivet		Purchased	No			110	Each	1,149.0000	16	64		8/12/07/19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		1146				64			
				121114		1146							
				ST318		3							
				120930		3							
MS20615M3-3 Rivet		Purchased	No			110	Each	1,250.0000	9	36		8/12/07/19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST323		1250				36			
				111650		10							
				116188		12							
				118384		1228							

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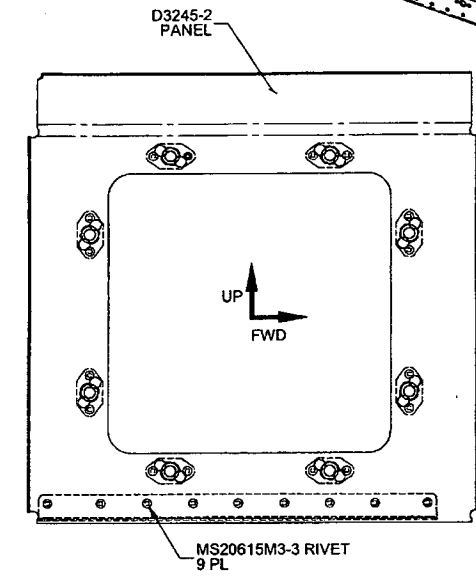
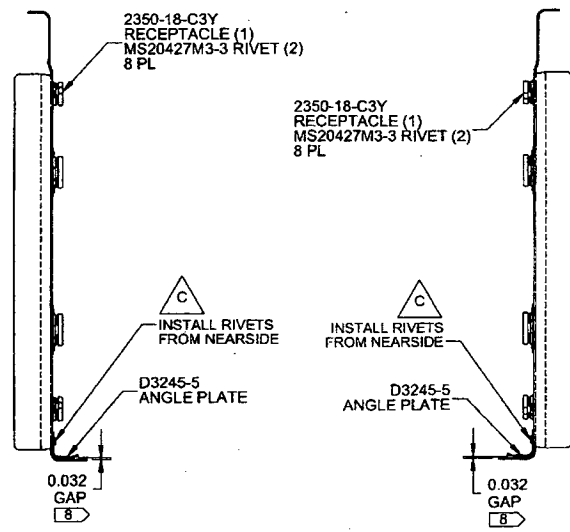
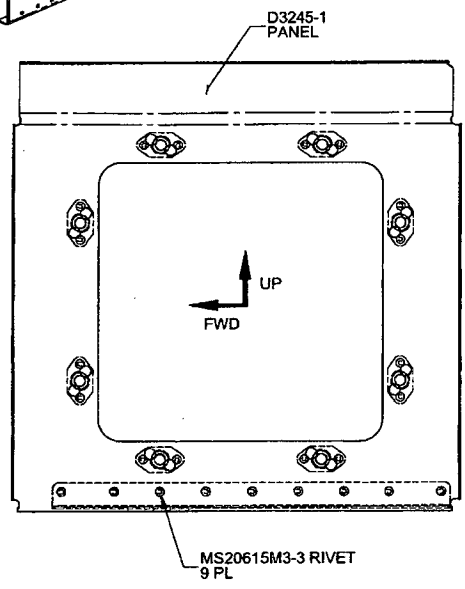
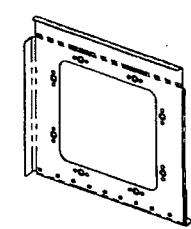
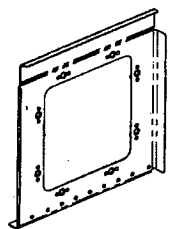
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NOTE: Date & initial all entries

UNC
SUB:
NO. 86872
RPD-076

D3245-041 ACCESS PANEL ASSY (LH)

D3245-042 ACCESS PANEL ASSY (RH)



QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSY (LH)
	X	D3245-042	ACCESS PANEL ASSY (RH)
1		D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
 - 7) WEIGHT: 0.83 lbs
 - 8) TEMPORARILY INSERT A.0.032" GAUGE-PLATE PRIOR TO RIVETING D3245-5 TO PANEL

C		ADDED NOTE 8, SHEET 1 SPECIFIED RIVET ORIENTATION (B4-1, B5-1). CHANGED 1/4-TURN STUD FROM 2351-20-009-C3Y TO 2351-20-012-C3Y (D5-2). HOLE SIZE WAS 0.098, 9 PLACES (D6-6). HOLE SIZE WAS 0.219, 8 PLACES (D7-5). REF: PAR 12-185		RP	12.04.11
B		REMOVE Ø0.204 HOLES FROM D3245-1/1F. REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING		MB	07.10.02
A		NEW ISSUE		RF	04.01.27
REV.	DESCRIPTION			BY	DATE
DESIGN	RF			DART AEROSPACE LTD	
DRAWN	MB			HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.			DRAWING NO.	REV. C
MFG. APPR.				D3245	SHEET 1 OF 7
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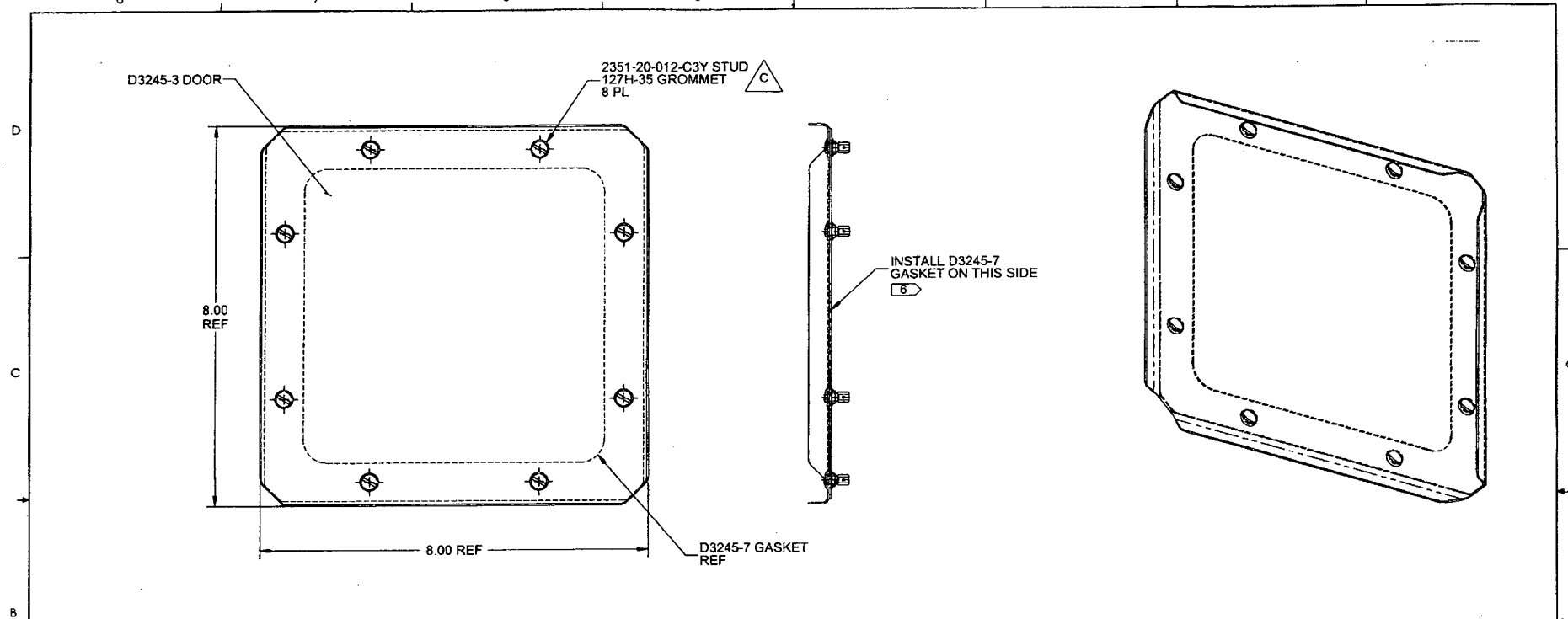
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8 7 6 5 4 3 2 1



D3245-043 DOOR ASSY

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	127H-35	GROMMET
8	2351-20-012-C3Y	STUD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 9) WEIGHT: 0.72 lbs

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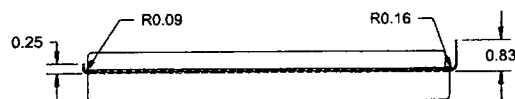
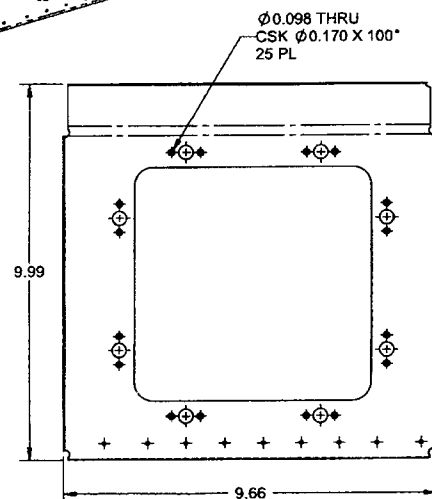
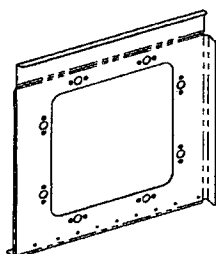
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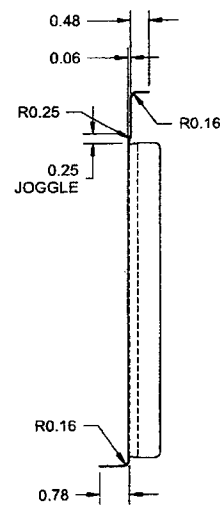
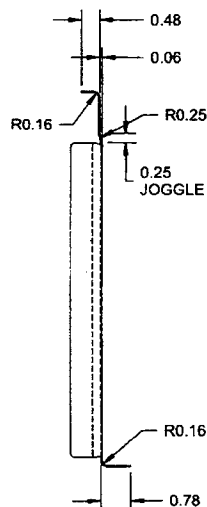
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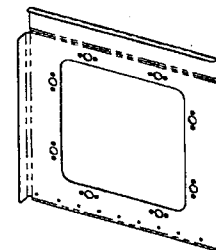
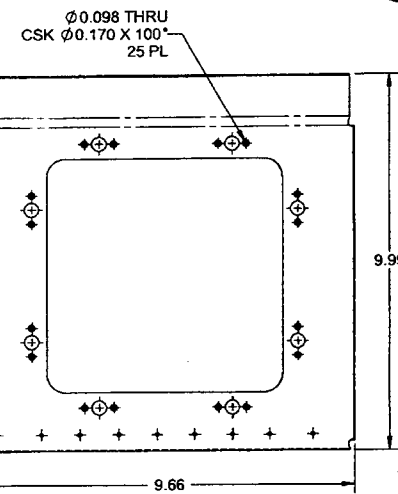
NOTE: Date & initial all entries



D3245-1 PANEL (LH)



D3245-2 PANEL (RH)



NOTES:

- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

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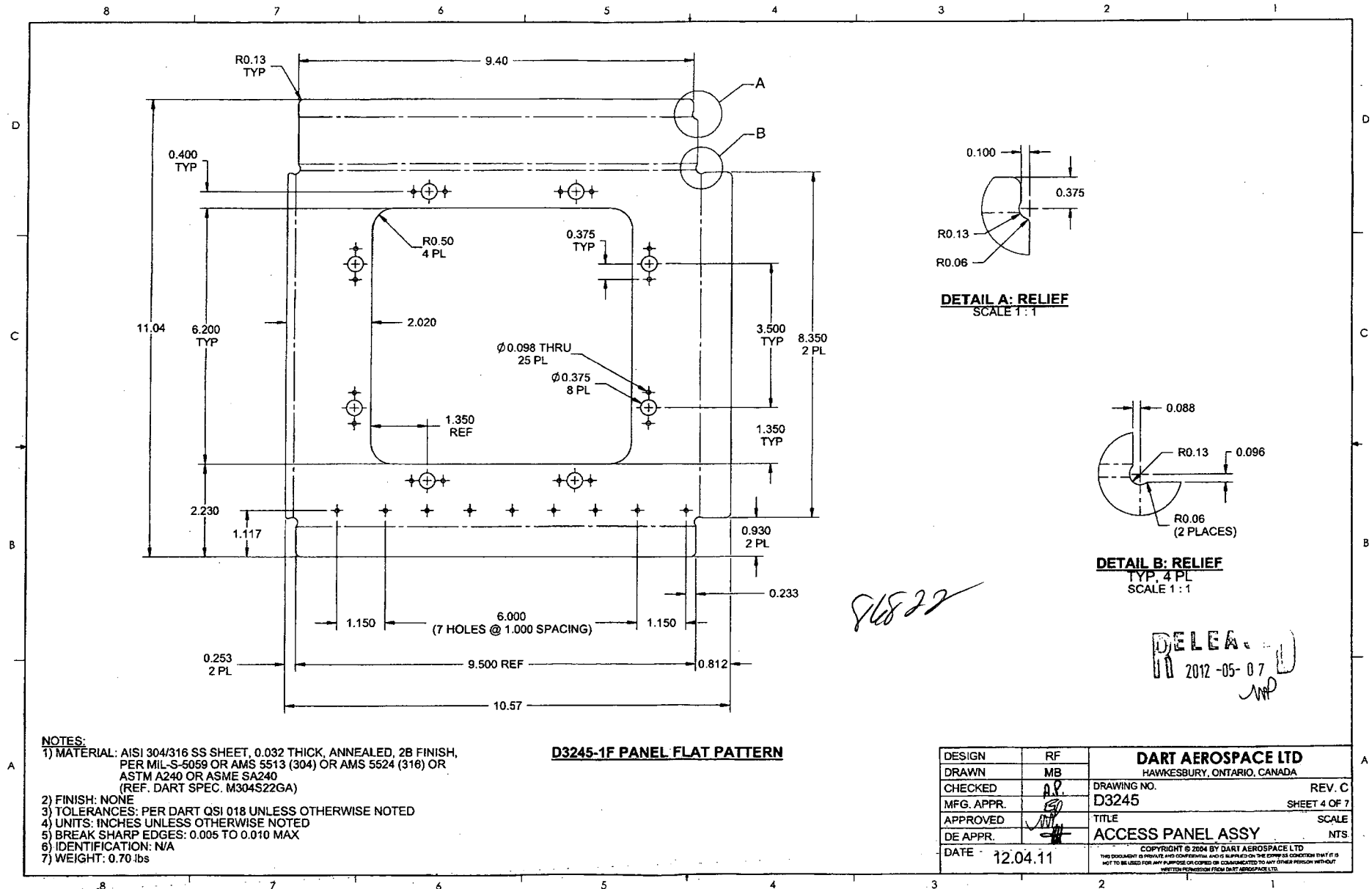
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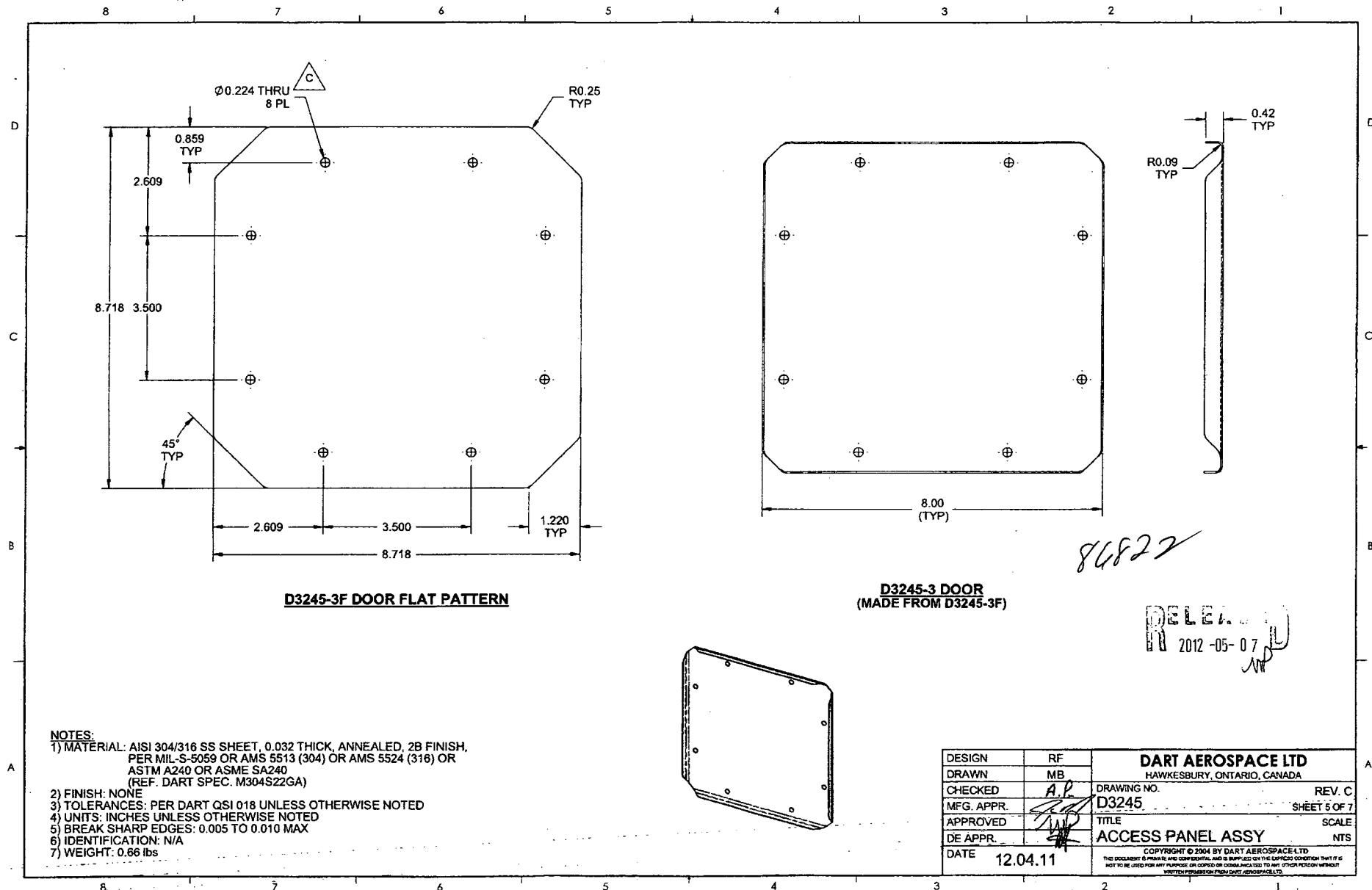
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NOTE: Date & initial all entries



D3245-3F DOOR FLAT PATTERN

**D3245-3 DOOR
(MADE FROM D3245-3F)**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.66 lbs

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MFG. APPR.	AP	D3245	SHEET 5 OF 7
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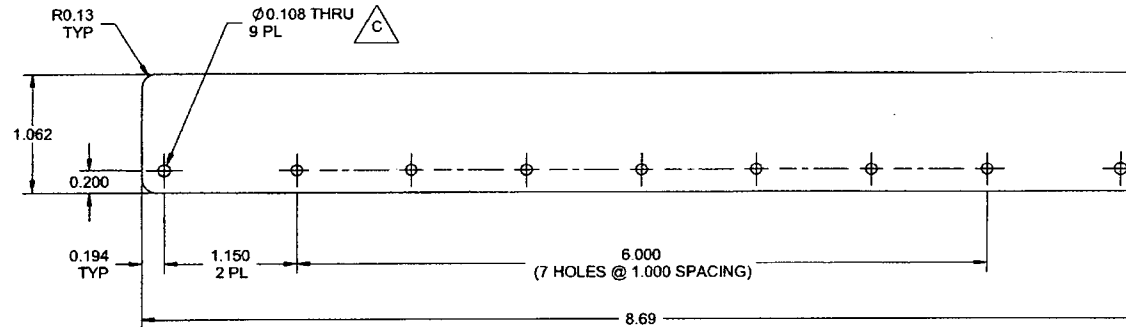
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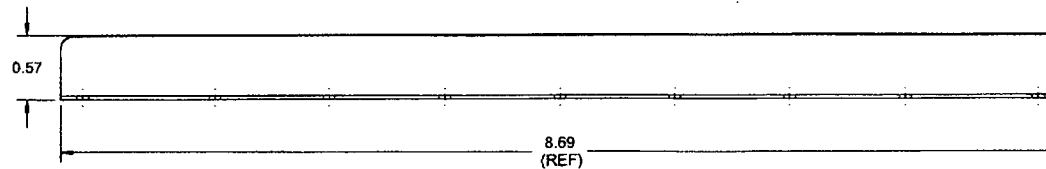
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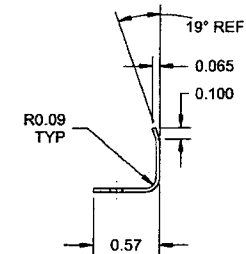
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D3245-5F FLAT PATTERN



D3245-5 ANGLE PLATE
(MAKE FROM D3245-5F)



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

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DEL. USED
R 2012-05-07
AP

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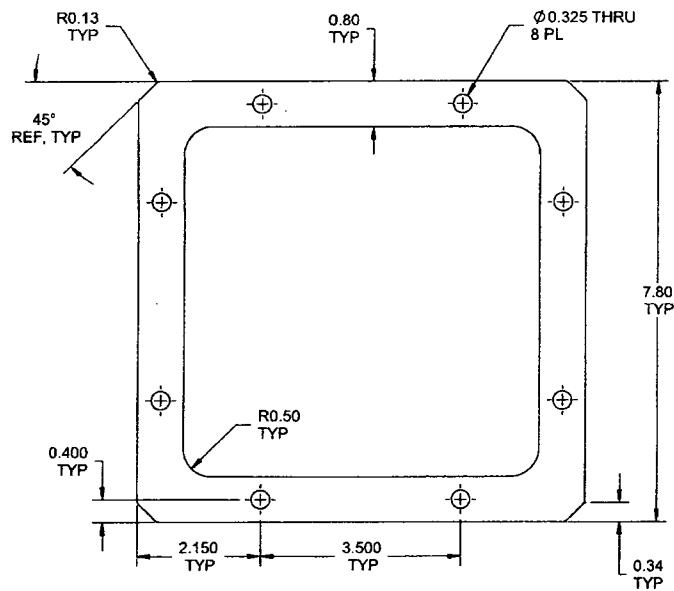
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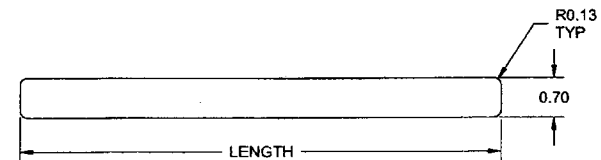
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D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK
PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A OR AMS 3232
(REF. DART SPEC. MDURAS.035)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01lbs

86822

REV. 002
2012-05-07
JMD

DESIGN	RF	DART AEROSPACE LTD	
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